

Date: Thursday, 29/05/2008 8:39:05 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 39546					
Estimate Number	: 11042					
P.O. Number	:			Part Number	: D28101	
This Issue	: 29/05/2008		S.O. No. :	Drawing Number	: D2810 / D2727	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	MACHINED PARTS	Drawing Revision	C / A1
Previous Run	: 35310			Material	:	
Written By	:			Due Date	: 30/05/2008	
Checked & Approved By	: JUL 08.5.29			Qty:	10	Um: Each
Comment	: Est. C 03.09.12 Rerformat; Added powder coat KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
		 
		Comment: Qty.: 2.3625 f(s)/Unit Total : 23.6250 f(s) 304 RD Tube .500 x .035W Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 Batch: M 10 8 215 SB 08/06/04 10
2.0	BRAKE NC	NC BRAKE
		 
		Comment: NC BRAKE 1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 2-Deburr → 08/06/04 + 10
3.0	QC5	INSPECT WORK TO CURRENT STEP
		 
		Comment: INSPECT WORK TO CURRENT STEP S 08/06/05 + 10
4.0	POWDER COATING	POWDER COATING
		 
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 START TIME: 10'30" OVEN TEMPERATURE: 320° FINISH TIME: 11'00"
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		 
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION FL 08/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 8:39:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 39546

Part Number: D28101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 265

DS 08/06/09 X(1)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/10 DS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

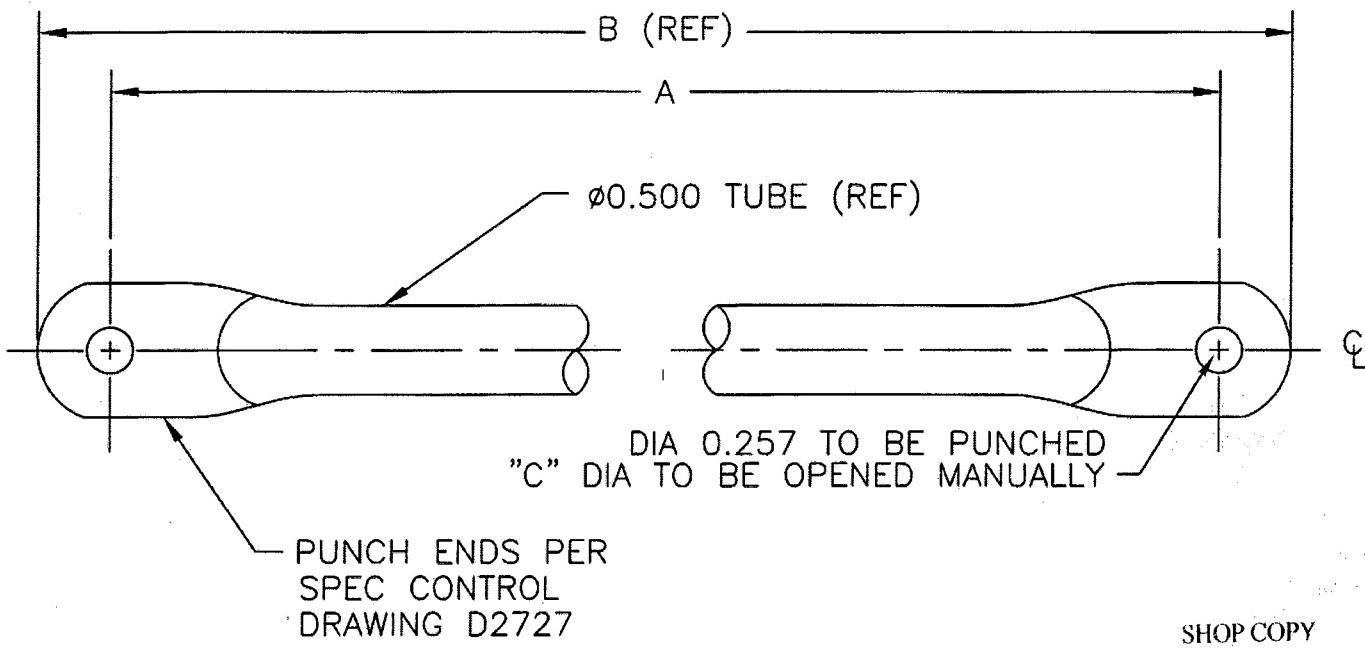
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2810
		REV. C SHEET 1 OF 1
DATE		TITLE STRUT
04.11.22		SCALE NTS
A	00.11.08	NEW ISSUE
B	03.09.11	ADD FINISH
C	04.11.22	ADD -5

RELEASED

05.03.14



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WITHOUT NOTICE
WORK ORDER
NO. 395460

PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.500 x 0.035 WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

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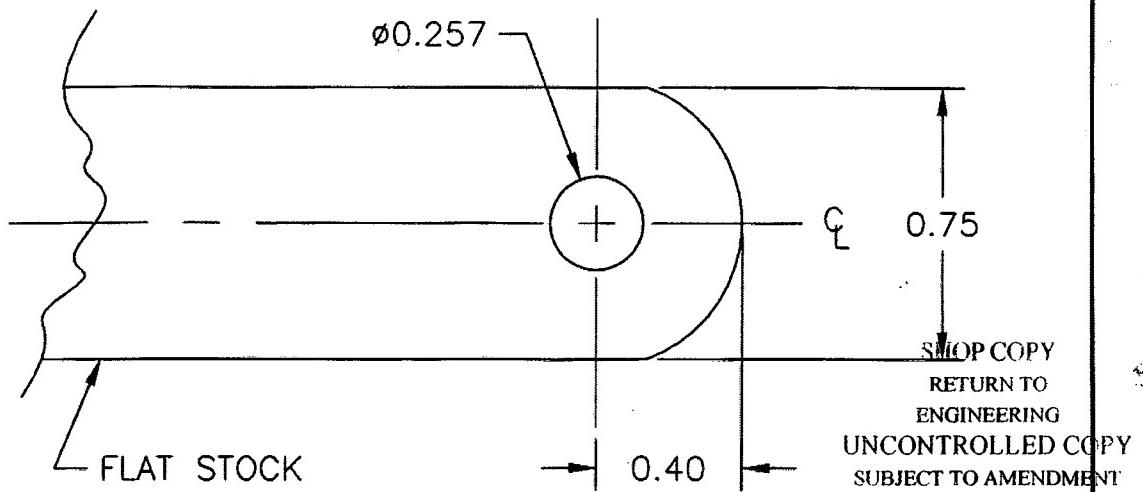
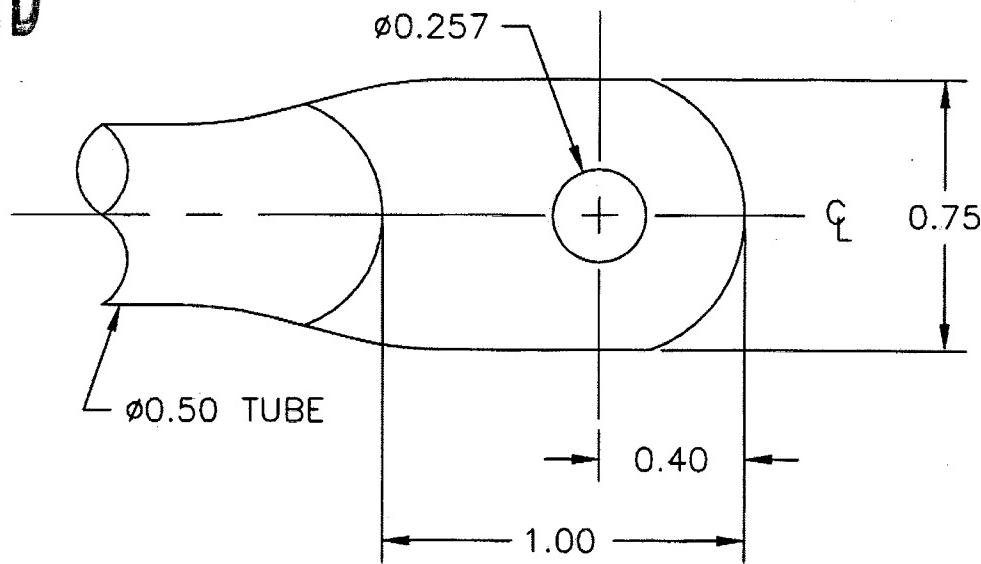
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DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MJY</i>	APPROVED <i>JF</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	HCP 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



WITHOUT NOTICE
WORK ORDER
NO. 395410